

# Work Order ID 86116

\*86116\*

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June-20-12 2:53:26 PM

Item ID: D3640-1

Revision ID:

Item Name: Belt Guide

Start Date: 20/06/2012 Start Qty: 6.00

Required Date: 04/07/2012 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

MLJ

Date: 12/06/20

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3640	Rev A								
100	BAND SAW	0.00							
*100*									
Bandsaw	Memo	0.00							
Jcaspa Bandsaw	Cut blank 4.700 " long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA670 & Dwg D3640 Rev: <u>A</u> 2-Deburr and Blend rad intersection with deburring tool.								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

12/08/08

12

12/08/08

12

12/08/09

12/08/08

12/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86116

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Item ID: D3640-1

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Belt Guide

Stop **\*NS2\***

Start Date: 20/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>ST 214</u>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

12-08-9

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86116

\*86116\*

Parent Item: D3640-1

\*D3640-1\*

Parent Item Name: Belt Guide

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDEL RINB0.75X1.250

Purchased

No

100

f

30.0775

0.4

2.526316

**\*MDFI RINB0 75X1 250\***

\*\*

4.799'

12/08/08

Delrin Bar

Location

Loc Qty

Loc Code

MAT055

30.077538

117985

0.5328

118066

1.16

119133

23.4

120035

4.984738

14535

1.190'

.794'

Delrin .750X1.000

116770

2.815

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

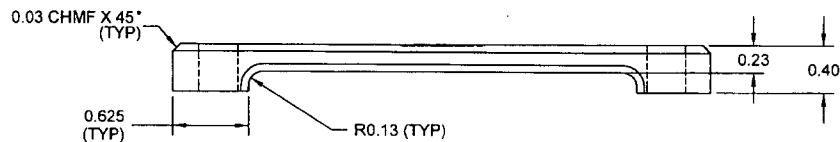
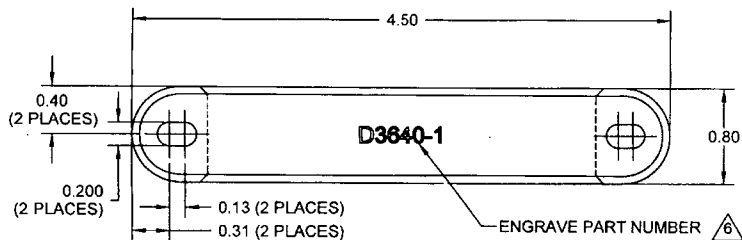
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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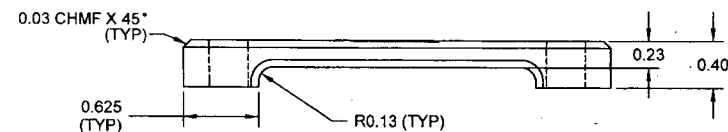
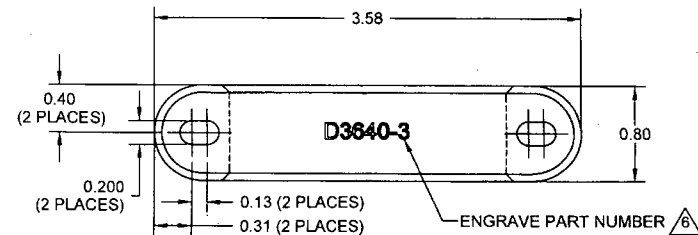
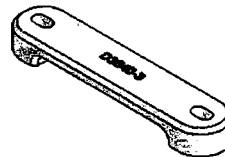
**NOTE:** Date & initial all entries





**D3640-1 BELT GUIDE**  
(WAS GENEVA P/N G10605-1)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86116 MLC  
12/06/20



**D3640-3 BELT GUIDE**  
(WAS GENEVA P/N G10605-2)

RELEASED  
07.07.27

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE: REPLACES G10605	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.27		

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA  
DRAWING NO. **D3640**  
TITLE **BELT GUIDE**  
SCALE 1:1  
REV. A  
SHEET 1 OF 1  
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